

Work Order ID 60402

July 7, 2010 9:53:58 AM



Page 1

Item ID: D3281-4L02

Accept



Setup Start



Revision ID:

Stop



Item Name: Floor Protector, Aft RH (Black)

Start Date: 7/07/10 Start Qty: 4.00



Cust Item ID:

Required Date: 7/14/10 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: CA

Date: 10/7/12

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3281

Rev D REV E

DSI 9504

A

P15 →

100

0.00



HAND FINISHING THERMOFORMING

0.00

Thermoform

Memo

Thermoforming Machine

Cut Blanks

XX BB 10/07/16

105

0.00



Dry Material

0.00

HandThermo

Memo

Hand Finishing Thermoforming

Dry Sheet as per QSI022 POLYCARBONATE

Temp: 240F

Time IN: 4:30 PM 10/07/18

Time OUT: 7:00 AM 10/07/19

XY BB 10/07/19

W/O: 60402		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
10/7/22	#100	Perm. Change. Fix Dwg Rev in header box to current/correct Rev. Also Fix Parts Rev to correct Dwg Rev.	CE	10.07.28			S 10/07/22	

Part No: D3281-4202 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 60402

July 7, 2010 9:53:58 AM



Page 2

Item ID:	D3281-4L02	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Floor Protector, Aft RH (Black)					
Start Date:	7/07/10	Start Qty:	4.00		Cust Item ID:	
Required Date:	7/14/10	Req'd Qty:	4.00		Customer:	
Reference:						
Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start
	QC:	Date:	SPC (Y/N):	Date:		Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110 Thermoform Thermoforming Machine	THERMOFORMING MACHINE Memo Thermoform as per Dwg. D3281 and Folio FTA 010 Dwg. Rev. <u>5</u> Folio Rev. <u>5</u>	0.00 0.00							<u>AY</u> <u>BB</u> 10/07/19
120 QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00							<u>X4</u> 10/07/19 <u>BB</u>
130 Thermoform Thermoforming Machine	HAND FINISHING THERMOFORMING Memo Trim to Finished Dimensions	0.00 0.00							<u>X4</u> 10/07/21 <u>BB</u>

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 60402

July 7, 2010 9:53:58 AM



Page 3

Item ID: D3281-4L02

Accept



Setup Start



Revision ID:

Stop



Item Name: Floor Protector, Aft RH (Black)

Start Date: 7/07/10 Start Qty: 4.00



Cust Item ID:

Required Date: 7/14/10 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

(X4) 10/07/23 BP

150



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

8/10/12

(X4)

160



Packaging

Packaging

Packaging

Memo

0.00

0.00

5/14/3

10-7-23 (X4) SP

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 60402

July 7, 2010 9:53:58 AM



Page 4

Item ID: D3281-4L02

Accept



Setup Start



Revision ID:

Stop



Item Name: Floor Protector, Aft RH (Black)

Start Date: 7/07/10 Start Qty: 4.00



Cust Item ID:

Required Date: 7/14/10 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

170

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

10/07/26
MF
10-7-23

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

July 7, 2010 9:53:57 AM

Page 1

Work Order ID: 60402



Parent Item: D3281-4L02



Parent Item Name: Floor Protector, Aft RH (Black)

Start Date: 7/07/10

Required Date: 7/14/10

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP Rev: A ☐ 04.07.01 ☐ New issue ☐ KJ/JLM

IPP Rev B 07.08.07 Thermoform in house DL

IPP Rev. C

ADd Step 105 Dry Material 10/04/21 DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

MLEXS.093-F6006-02

Purchased

No

sf

1,057.296

4.333

17.332



GE PLASTICS LEXAN SHEET

Location

therm

110877

Loc Qty

1057.296

1057.296

Loc Code

XY BB 10/07/16

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	60402
Description: Floor Protector, Aft RH	Part Number:	D3281-4
Inspection Dwg: D3281 Rev: D		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than 0.1875"	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: [Signature] Date: 10/07/21

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
17.8	+/-0.100	17.7	✓			
17.1	+/-0.100	17.05	✓			
14.3	+/-0.100	14.3	✓			
0.95	+/-0.030	.96	✓			
0.25	+/-0.030	N/A				
3.1	+/-0.100	3.1	✓			
0.050	Min	.059	✓			
0.070	Min	.074	✓			

Measured by: [Signature] Date:

Audited by: [Signature] 10 07 21 Date:

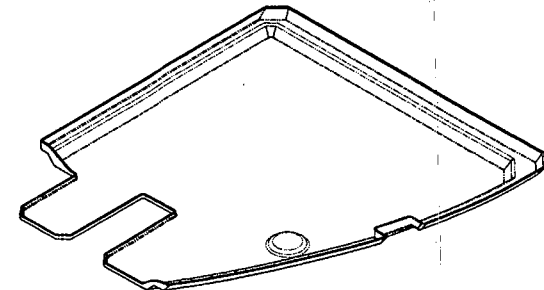
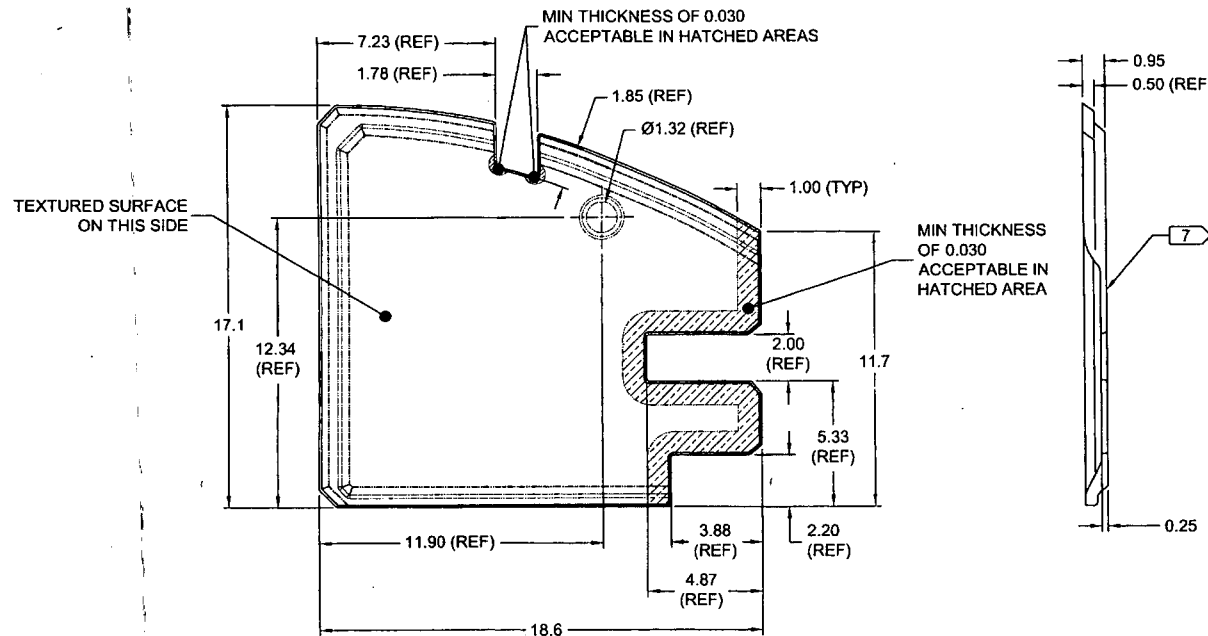
Prototype Approval: N/A Date: N/A

Rev	Date	Change	Revised by	Approved
A	08.02.28	New Issue	KJ/DL	
B	08.04.16	Dimensions updated per Dwg Rev D	KJ/DL <u>[Signature]</u>	<u>[Signature]</u>

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CX10/7/17



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2010-02-03
MP

D3281-1 FLOOR PROTECTOR

D3281-1 NOTES:

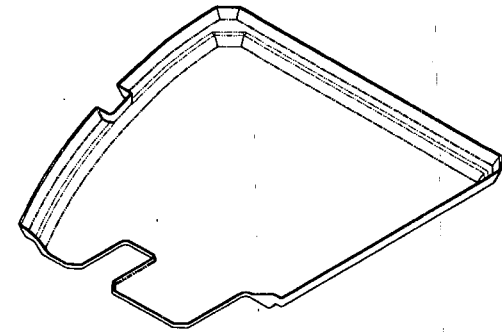
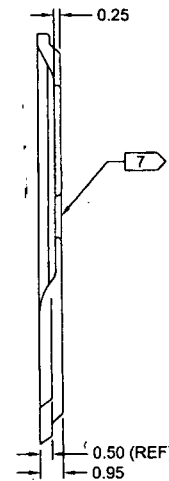
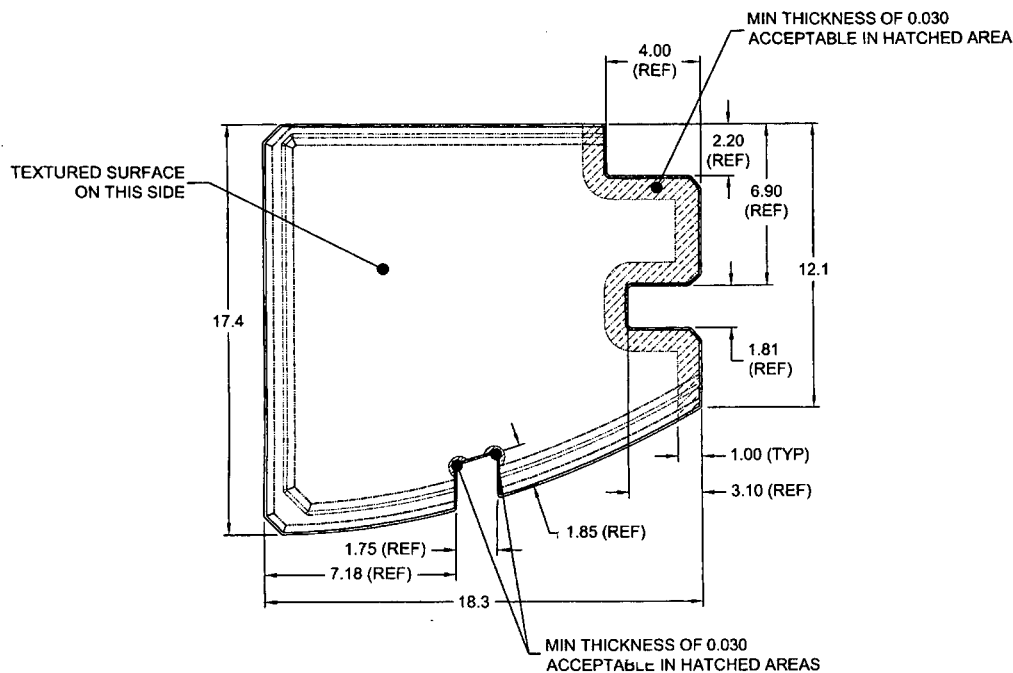
- 1) THERMOFORM WITH MOLD D3281-1T1 PER DART QSI 022; TRIM AS SHOWN
MINIMUM THICKNESS AFTER FORMING: 0.070" EXCEPT WHERE INDICATED
- 2) MATERIAL: LEXAN F6006, BLACK No. 701, 0.093" THICK
(REF DART SPEC MLEXS.093-F6006-02)
- 3) FINISH: NONE
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.010 MAX
- 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3281-1" AND BATCH NUMBER "BXXXXX" ON SMOOTH SIDE OF PART USING VIBRATING STYLUS
- 8) WEIGHT: 0.95 lb

E	-3/4 NOW TRIMMED FLAT: RMV 0.25 BEVEL TO FACILITATE TRIMMING (ZN D6-3, D4-4)	CP	10.01.05
D	THICKNESS 0.093 WAS 0.125, MIN THICKNESS 0.070 WAS 0.080, P/N AND B/N ID WITH VIBRATING STYLUS (ZN A7-1, A7-2, A7-3, A7-4); D3281-4 NOW ON PAGE 4; CORRECT WEIGHTS (ZN A8-1, A8-2, A8-3, A8-4)	PH	08.03.28
C	UPDATE DIMS TO MATCH PARTS: COLOUR 701 WAS 700; GENERAL UPDATE	LE	07.10.09
B	NOW LEXAN; DIMS AS MANUFACTURED	CP	05.11.25
A	NEW ISSUE	CP	04.05.03
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>JP</i>		
DRAWN	<i>JP</i>		
CHECKED	<i>JP</i>		
MFG. APPR.	<i>JP</i>		
APPROVED	<i>JP</i>		
DE APPR.	<i>JP</i>		
DATE	10.01.05		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. REV. E
D3281 SHEET 1 OF 4
TITLE SCALE
FLOOR PROTECTOR NTS

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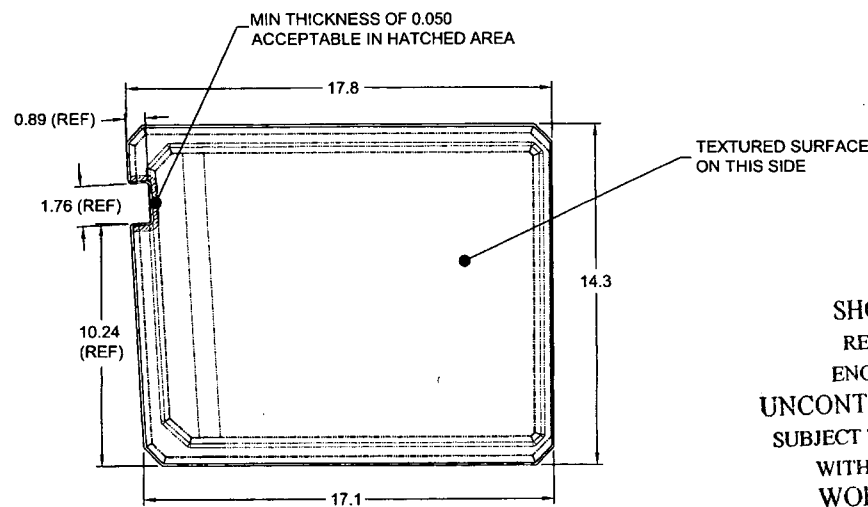
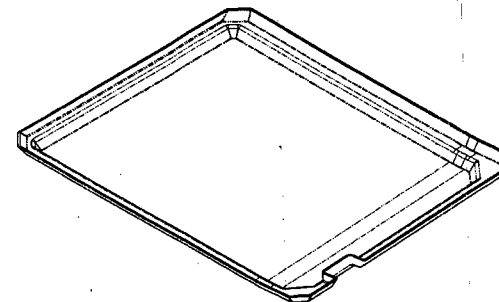
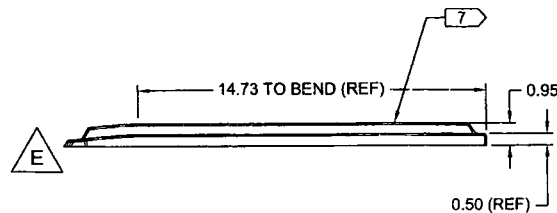
RELEASED
2010-02-03

D3281-2 FLOOR PROTECTOR

D3281-2 NOTES:

- 1) THERMOFORM WITH MOLD D3281-2T1 PER DART QSI 022; TRIM AS SHOWN
MINIMUM THICKNESS AFTER FORMING: 0.070" EXCEPT WHERE INDICATED
- 2) MATERIAL: LEXAN F6006, BLACK No. 701, 0.093" THICK
(REF DART SPEC MLEXS.093-F6006-02)
- 3) FINISH: NONE
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.010 MAX
- 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3281-2" AND BATCH NUMBER "BXXXXX" ON SMOOTH SIDE OF PART USING VIBRATING STYLUS
- 8) WEIGHT: 0.97 lb

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MFG. APPR.	41	D3281	SHEET 2 OF 4
APPROVED	41	TITLE	SCALE
DE APPR.	41	FLOOR PROTECTOR	NTS
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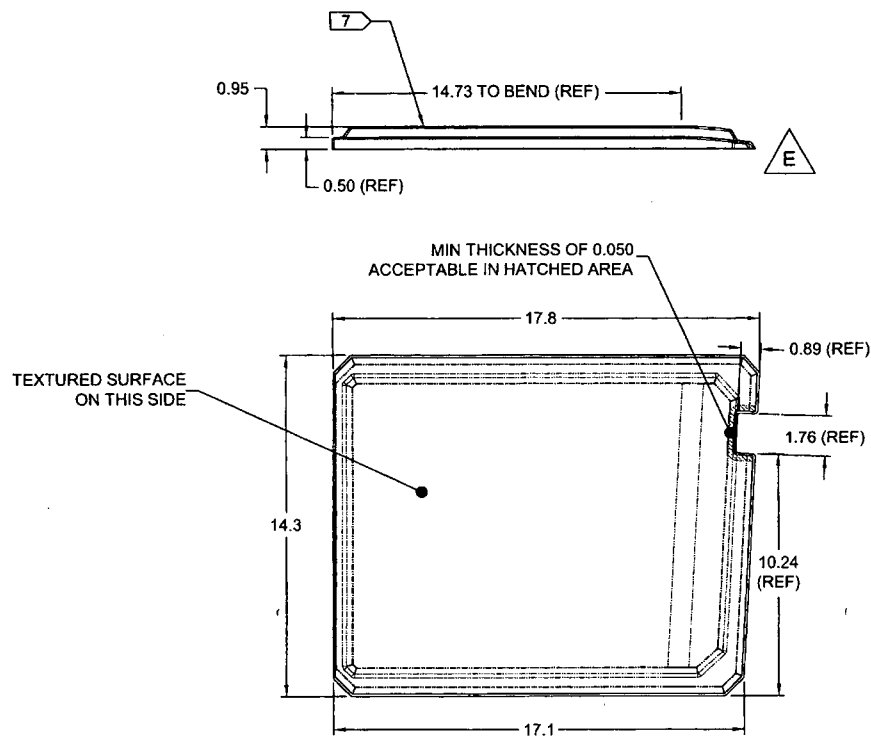
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2010-02-03

D3281-3 FLOOR PROTECTOR

D3281-3 NOTES:

- 1) THERMOFORM WITH MOLD D3281-3T1 PER DART QSI 022; TRIM AS SHOWN
MINIMUM THICKNESS AFTER FORMING: 0.070" EXCEPT WHERE INDICATED
- 2) MATERIAL: LEXAN F6006, BLACK No. 701, 0.093" THICK
(REF DART SPEC MLEXS.093-F6006-02)
- 3) FINISH: NONE
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.010 MAX
- 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3281-3" AND BATCH NUMBER "BXXXXX" ON SMOOTH SIDE OF PART USING VIBRATING STYLUS
- 8) WEIGHT: 0.87 lb

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MFG. APPR.		D3281	SHEET 3 OF 4
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DE APPR.		FLOOR PROTECTOR	NTS
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D3281-4 FLOOR PROTECTOR

D3281-4 NOTES:

- 1) THERMOFORM WITH MOLD D3281-4T1 PER DART QSI 022; TRIM AS SHOWN
- 2) MATERIAL: LEXAN F6006, BLACK No. 701, 0.093" THICK
(REF DART SPEC MLEXS.093-F6006-02)
- 3) FINISH: NONE
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.010 MAX
- 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3281-4" AND BATCH NUMBER "BXXXXX" ON SMOOTH SIDE OF PART USING VIBRATING STYLUS
- 8) WEIGHT: 0.87 lb

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MFG. APPR.	ELO	D3281	SHEET 4 OF 4
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DE APPR.	h	FLOOR PROTECTOR	NTS
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DRAWING NO. D3281	TITLE FLOOR PROTECTOR	REV. E	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3281-E-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>9</i>	CHECKED <i>h</i>	MFG. APPR. <i>h</i>	APPROVED <i>h</i>	DE APPR. <i>h</i>			
DATE 10.02.24	DATE 10.02.25	DATE 10/02/25	DATE 10.02.25	DATE 10.02.25			

PURPOSE

ADD "D3281-xL08" MATERIAL OPTION. EXISTING PARTS TO BE IDENTIFIED AS "D3281-xL02"

CHANGE

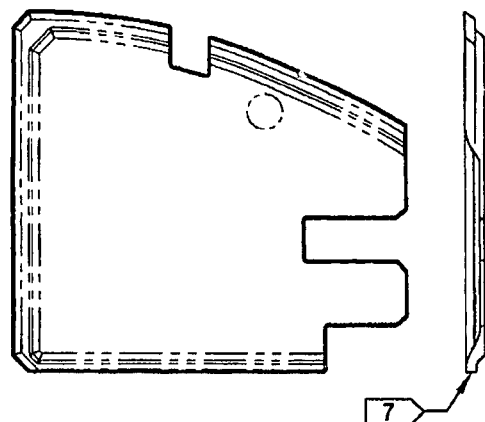
D3281-xL08 PARTS ARE EQUIVALENT TO THE RESPECTIVE "-x" PARTS EXCEPT AS DETAIL BELOW. THE MATERIAL, IDENTIFICATION, AND WEIGHT NOTES ARE AMENDED AS FOLLOWS:

- 2) MATERIAL: -xL02 = LEXAN F6006, BLACK No. 701, 0.093" THICK (MLEXS.093-F6006-02)
 -xL08 = LEXAN 90318 (PROTECT-A-GLAZE), 0.118 THICK, 112-CLEAR (MLEXS.118-90318-08)

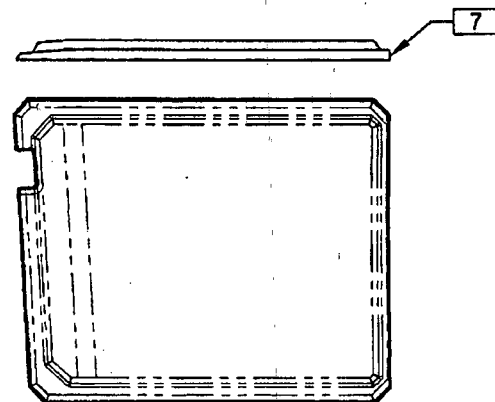
- 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3281-xLxx" AND B/N "Bxxxx" ON SMOOTH SIDE OF PART USING VIBRATING STYLUS.
 FOR -xL08 PARTS, LOCATE ENGRAVING ALONG PERIMETER OF PART AS SHOWN.

- 8) WEIGHT: D3281-1L02/-2L02 = 0.95 lb D3281-1L08/-2L08 = 1.13 lb
 D3281-1L02/-2L02 = 0.87 lb D3281-3L08/-4L08 = 1.05 lb

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D3281-1L08 FLOOR PROTECTOR (SHOWN)
D3281-2L08 FLOOR PRETECTOR (OPPOSITE)
 LOCATION OF ENGRAVING



D3281-3L08 FLOOR PROTECTOR (SHOWN)
D3281-4L08 FLOOR PRETECTOR (OPPOSITE)
 LOCATION OF ENGRAVING

RELEASED
 2010-02-26